

Handy Flo® 737

GENERAL DESCRIPTION

Handy Flo 737 is an aggressive, chloride based flux system in a dry powder form designed for use with aluminum brazing filler metals for joining of 1000, 3000, 6000 and some 5000 and 7000 series aluminum alloys in an open air brazing processes. This product is corrosive and the flux residue must be removed from the assembly following the brazing operation.

Handy Flo 737 removes surface oxides that form on aluminum, which allows for excellent melt and flow characteristics of the filler metal.

Some of the performance advantages of Handy Flo 737 include:

- This product can be mixed with water or N-PROPYL Alcohol to form slurry
- Proper post braze cleaning or rinsing with water will eliminate acid post clean-up procedures
- The flux system will not etch or roughen the surface of the fillet, nor will it make fillet darker than the adjoining aluminum base metal

This flux system is recommended for use in an open air or torch heating applications. If formed into slurry, Handy Flo 737 does not require drying prior to brazing and will remain in place and not flake off or blow off the assemblies during the heating cycle of the brazing process.

PRODUCT APPLICATION

Handy Flo DF 737 becomes fully molten and active by 1000°F (5438C). It is recommended for use with AL 716 (American Welding Society (AWS) A5.8/A5.8M BAlSi-3) and AL 718 (AWS A5.8/A5.8M BAlSi-4) braze filler metals in a powder, ring or wire form.

BRAZING CHARACTERISTICS

Handy Flo 737 will exhibit fast flow characteristics. This product is corrosive and a post-braze cleaning or rinsing operation is required.

WARRANTY & STORAGE

Lucas-Milhaupt, Inc. warrants their Brazing and Soldering Paste products for 90 days from the date of shipment if stored in the original unopened container. Optimal storage conditions would be 65°F (18°C) - 75°F (24°C), clean and dry. It is recommended that the paste products are stored away from direct heat. Paste may require mixing to regain a homogenous mixture before application.

The 90 day warranty should not be interpreted as the shelf or useful life of the product. The paste products may be used well beyond the 90 day warranty, unless customer testing or production results indicate unsatisfactory performance of the product.

AVAILABLE PACKAGING

Handy Flo products are available in various size jars.

SPECIFICATIONS

Handy Flo 737 conforms to the following specifications: N/A

APPLICABLE PRODUCT CODE(S)

The applicable Lucas-Milhaupt product code(s) for this technical data sheet: 83-737.

SAFETY INFORMATION

The operation and maintenance of brazing equipment or facility should conform to the provisions of American National Standard (ANSI) Z49.1, "Safety in Welding and Cutting". For more complete information refer to the Material Safety Data Sheet for Handy Flo 737.

WARRANTY CLAUSE

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